

Work Order ID 134821

134821

Page 1

July 21, 2015 1:29:30 PM

Item ID: D4172-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Supporting Plate

Start Date: 7/21/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/11/2015 Req'd Qty: 2.00

2

Customer:

Reference:

/MLJ

Approvals:

Process Plan: Slay 15/7/21

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4172	B								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

(2)

02/15/08/27

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(2)

02/15/08/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Page 2

SEP 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 134821

134821

Page 3

July 21, 2015 1:29:30 PM

Item ID: D4172-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Supporting Plate
 Start Date: 7/21/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/11/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location 11c222	0.00			DAS				
150					30				
Packaging	Memo	0.00			9-89				
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ML5 SEP 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

July 21, 2015 1:29:48 PM

Page 1

Work Order ID: 134821

134821

Parent Item: D4172-1

D4172-1

Parent Item Name: Supporting Plate

Start Date: 7/21/2015

Required Date: 8/11/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	59.5259	1.5645	3.293684			

M6061T6S 125

6061-T6 .125 Sheet

06/15/08/27

Location

Loc Qty

Loc Code

MAT020

59.52585

m127454

1.75

m130745

4.08945

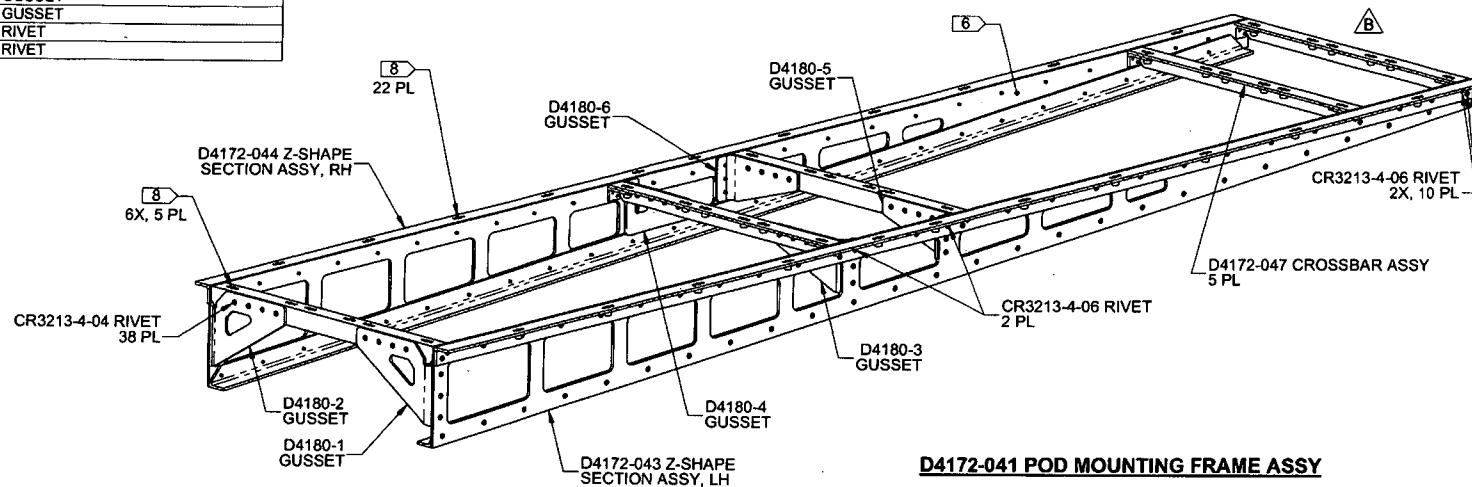
m131352

53.6864

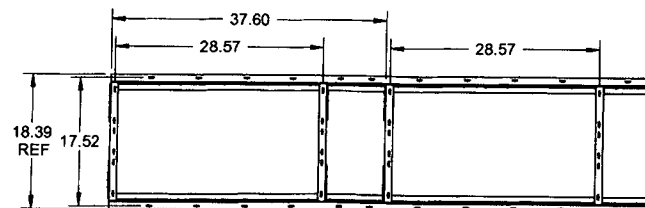
132876

6.3

ITEM	QTY .041	P/N	DESCRIPTION
	X	D4172-041	POD MOUNTING FRAME
1	1	D4172-043	Z-SHAPE SECTION ASSY, LH
2	1	D4172-044	Z-SHAPE SECTION ASSY, RH
3	5	D4172-047	CROSSBAR ASSY
4	1	D4180-1	GUSSET
5	1	D4180-2	GUSSET
6	1	D4180-3	GUSSET
7	1	D4180-4	GUSSET
8	1	D4180-5	GUSSET
9	1	D4180-6	GUSSET
10	38	CR3213-4-04	RIVET
11	24	CR3213-4-06	RIVET



D4172-041 POD MOUNTING FRAME ASSY



SUPPLEMENTAL VIEWS

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1 (PERMANENT INK MARKER)
 - 7) WEIGHT: 12.5 lbs
 - 8) MASK PRIOR TO POWDER COATING

134 821
15/7/21
SH

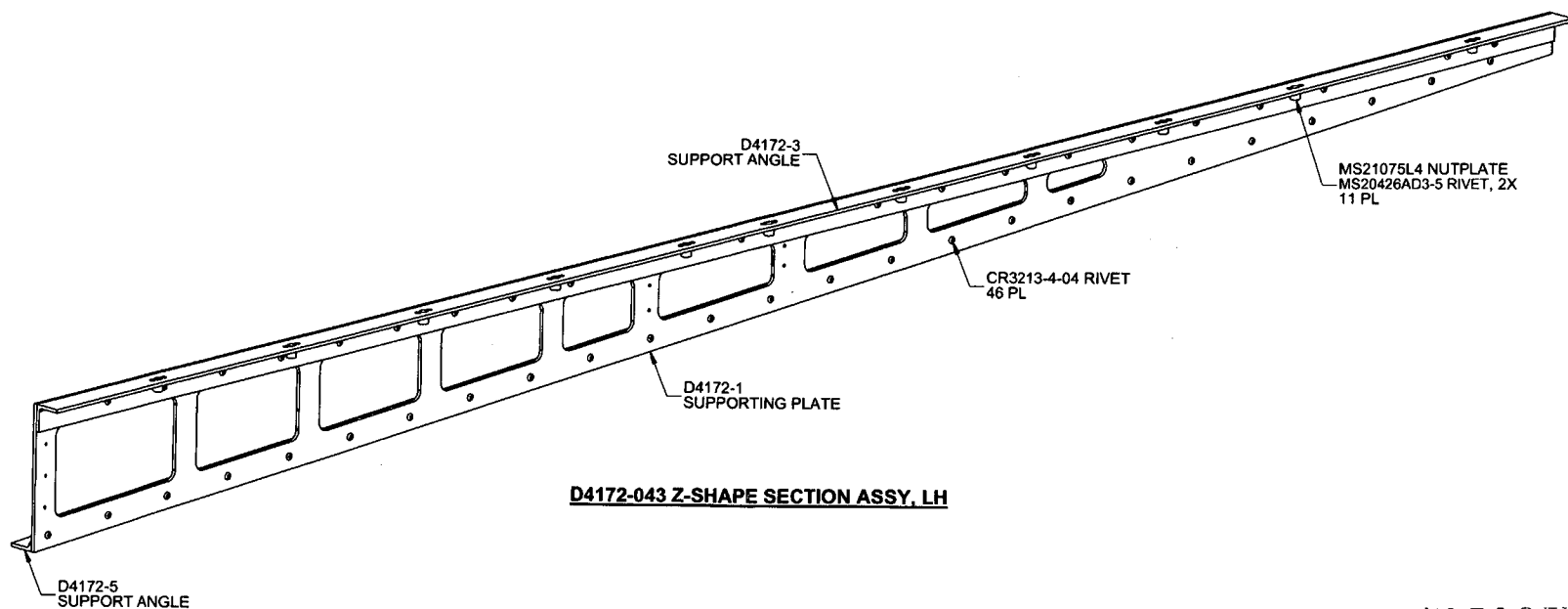
RELEASED
2013-04-02

B	REMOVED D4181-1 AND MS24694-S100 SCREWS, SEE NEXT ASSEMBLY	MB	13.02.25
A	NEW ISSUE	MB	10.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.02.25		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4172	REV. B
TITLE POD MOUNTING FRAME ASSY	SHEET 1 OF 7
SCALE NTS	

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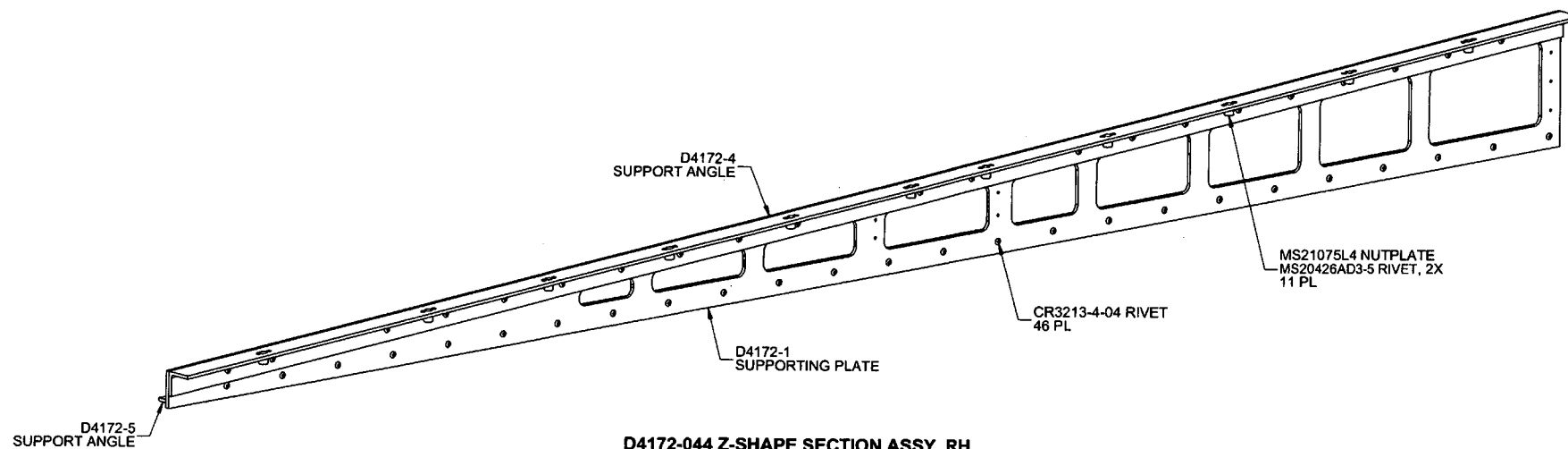
ITEM	QTY -443	P/N	DESCRIPTION
	X	D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	22	MS20426AD3-5	RIVET, CSK
5	11	MS21075L4	NUT PLATE
6	46	CR3213-4-04	RIVET



NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.13 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D4172	REV. B
MFG. APPR.			SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	NTS
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ITEM	QTY -044	P/N	DESCRIPTION
	X	D4172-044	Z-SHAPE SECTION ASSY, RH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-4	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	22	MS20426AD3-5	RIVET, CSK
5	11	MS21075L4	NUT PLATE
6	46	CR3213-4-04	RIVET



D4172-044 Z-SHAPE SECTION ASSY, RH

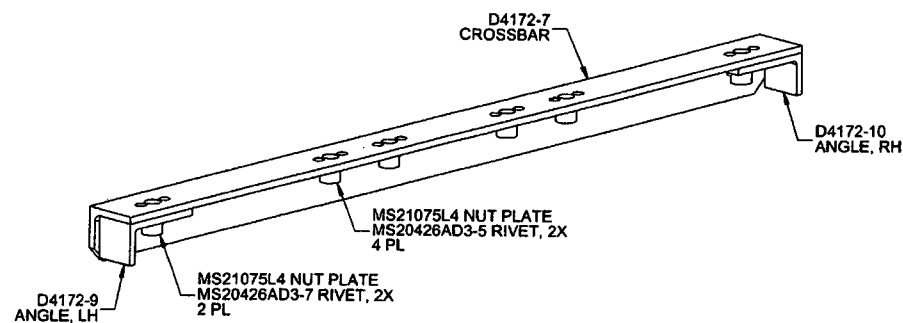
RELEASED
2013-04-02

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.13 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.S.	DRAWING NO.	REV. B
MFG. APPR.		D4172	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	NTS
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ITEM	QTY -047	P/N	DESCRIPTION
	X	D4172-047	CROSSBAR ASSY
1	1	D4172-7	CROSSBAR
2	1	D4172-9	ANGLE
3	1	D4172-10	ANGLE
4	6	MS21075L4	NUT PLATE
5	8	MS20426AD3-5	RIVET, CSK
6	4	MS20426AD3-7	RIVET, CSK



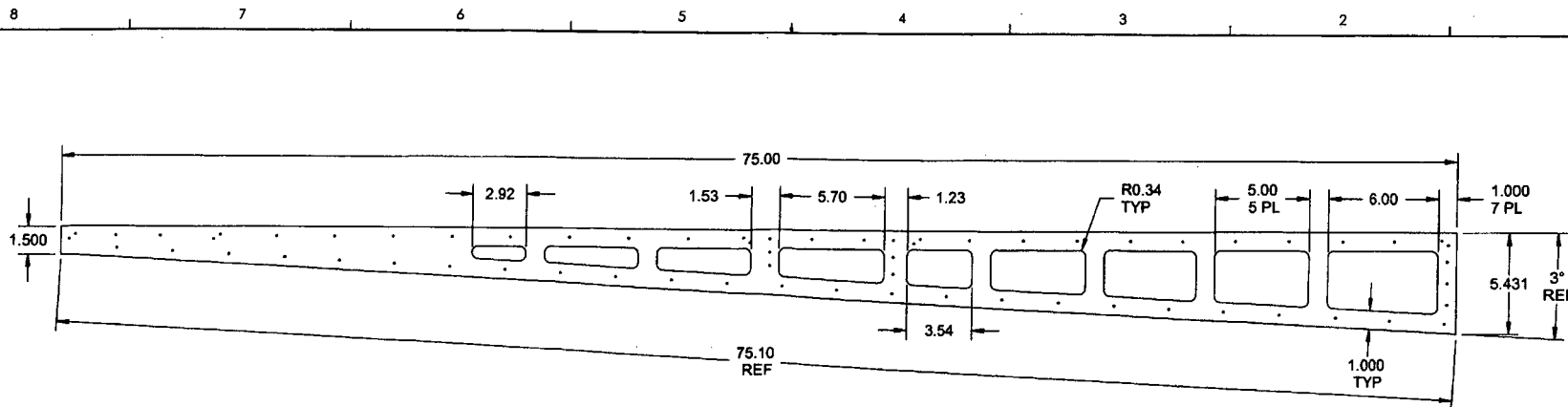
D4172-047 CROSSBAR ASSY

NOTES:

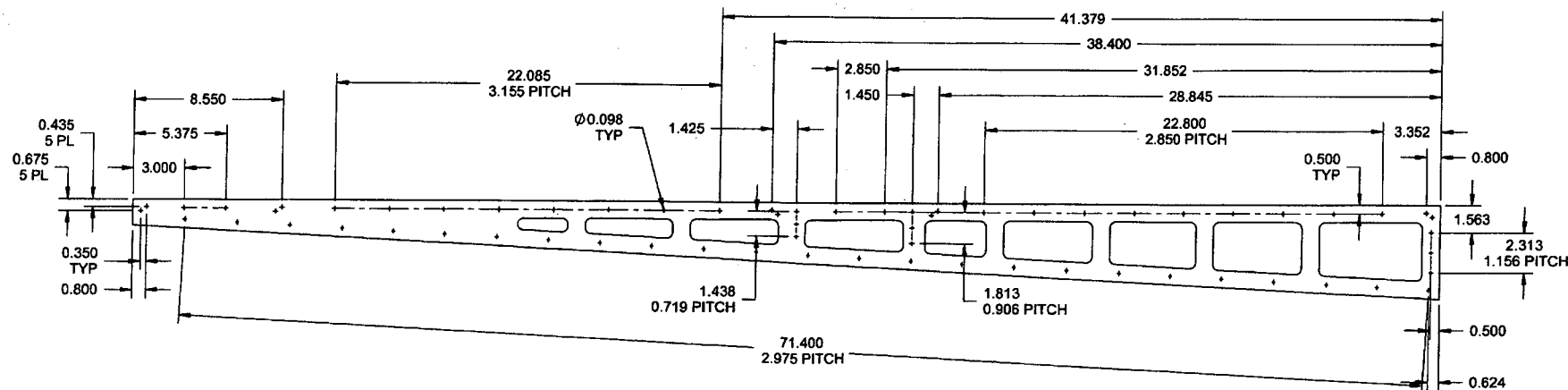
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4172	REV. B
MFG. APPR.			SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	NTS
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RELEASED
2013-04-02
W



D4172-1 SUPPORTING PLATE

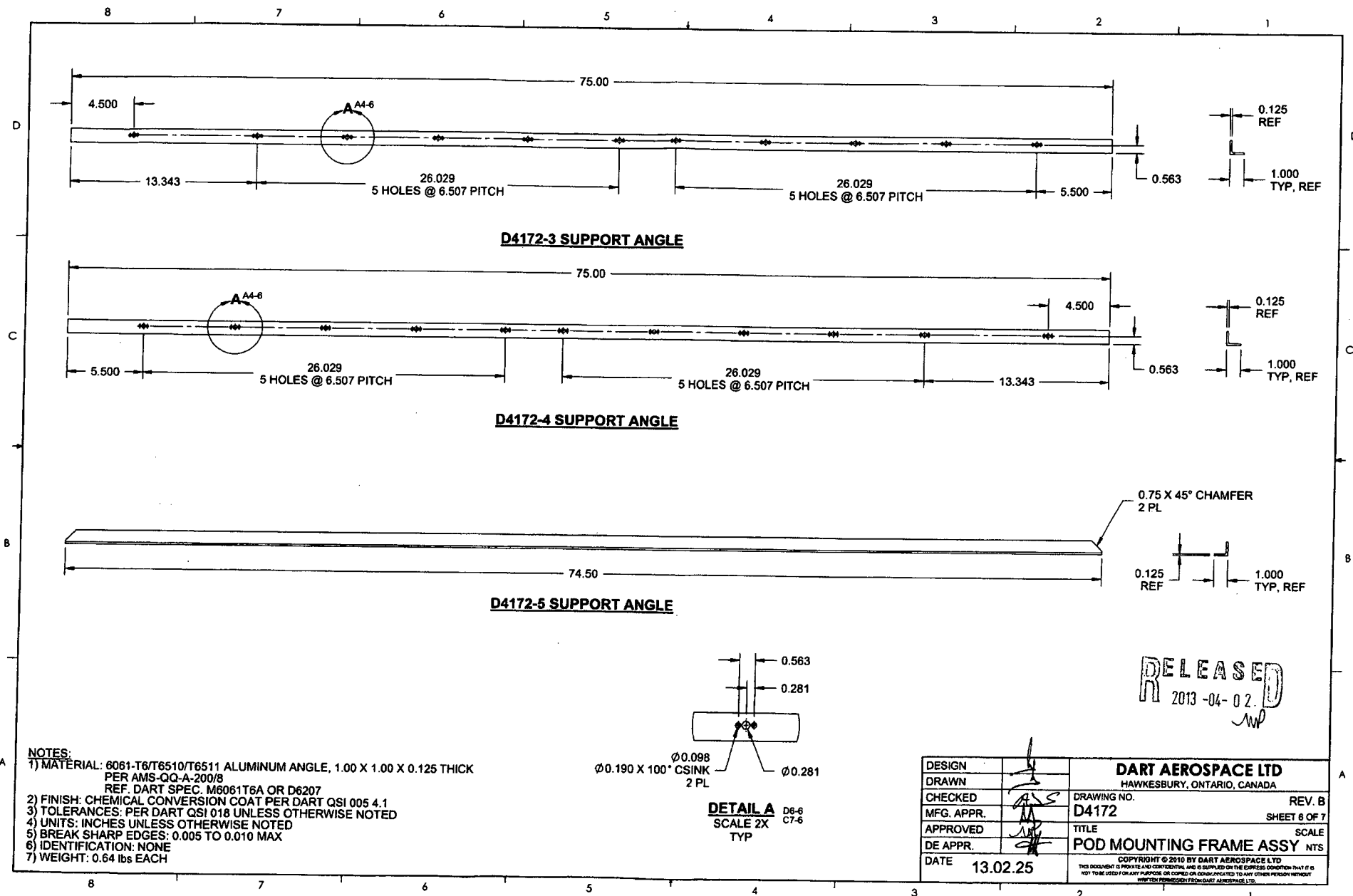


SUPPLEMENTAL VIEW

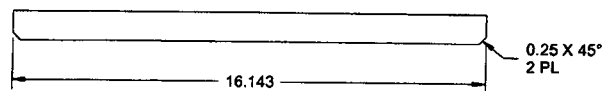
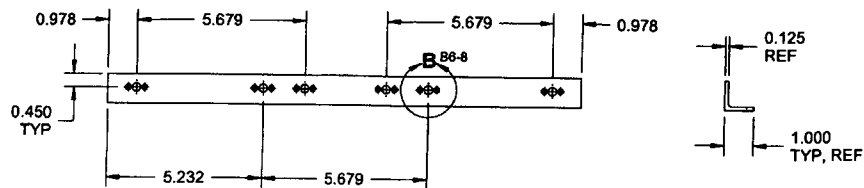
RELEASED
2013-04-02

- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.78 lbs

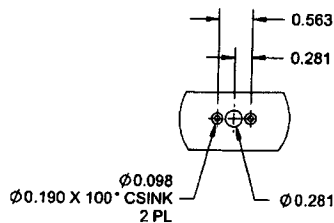
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4172	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	NTS
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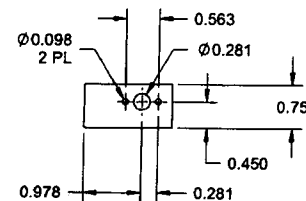
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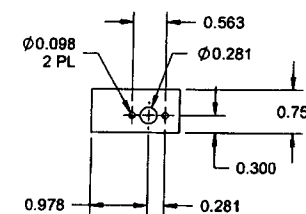
D4172-7 CROSSBAR



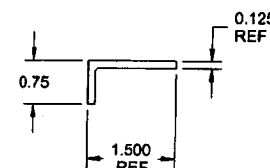
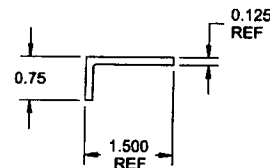
DETAIL B
D6-8
SCALE 2X
TYP



D4172-9 ANGLE



D4172-10 ANGLE



NOTES:

1) MATERIAL

D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK

PER AMS-QQ-A-200/8

REF. DART SPEC. M8061T6A OR D6207

D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK

PER AMS-QQ-A-200/8

REF. DART SPEC. M8061T6A OR D6203

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

RELEASED
2013-04-02

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4172	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	NTS
DATE	13.02.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	134821
Description: Supportin Plate		Part Number:	D4172-1
Inspection Dwg: D4172	Rev: <i>AB</i>	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	<i>Ø.098</i>	<i>/</i>		<i>Viper 2</i>	
1.500	+/-0.010	<i>1.503</i>	<i>/</i>		<i>Viper 01</i>	
2.92	+/-0.030	<i>2.922</i>	<i>/</i>		<i>Tape</i>	
1.53	+/-0.030	<i>1.533</i>	<i>/</i>			
5.70	+/-0.030	<i>5.707</i>	<i>/</i>			
1.23	+/-0.030	<i>1.234</i>	<i>/</i>			
5.00	+/-0.030	<i>5.000</i>	<i>/</i>			
6.00	+/-0.030	<i>6.00</i>	<i>/</i>			
1.000	+/-0.010	<i>1.003</i>	<i>/</i>			
5.431	+/-0.010	<i>5.437</i>	<i>/</i>			
3.54	+/-0.030	<i>3.57</i>	<i>/</i>			
0.800	+/-0.010	<i>.804</i>	<i>/</i>			
0.350	+/-0.010	<i>.353</i>	<i>/</i>			
0.675	+/-0.010	<i>.677</i>	<i>/</i>			
0.435	+/-0.010	<i>.438</i>	<i>/</i>			
3.000	+/-0.010	<i>3.006</i>	<i>/</i>			
5.375	+/-0.010	<i>5.378</i>	<i>/</i>			
8.550	+/-0.010	<i>8.550</i>	<i>/</i>			
22.085	+/-0.010	<i>22.089</i>	<i>/</i>			
3.155	+/-0.010	<i>3.159</i>	<i>-</i>			
1.438	+/-0.010	<i>1.439</i>	<i>/</i>			
0.719	+/-0.010	<i>.722</i>	<i>-</i>			
1.425	+/-0.010	<i>1.423</i>	<i>-</i>			
41.379	+/-0.010	<i>41.379</i>	<i>/</i>			
38.400	+/-0.010	<i>38.400</i>	<i>/</i>			
31.852	+/-0.010	<i>31.852</i>	<i>-</i>			
28.800	+/-0.010	<i>28.800</i>	<i>-</i>			
2.850	+/-0.010	<i>2.853</i>	<i>/</i>			
1.450	+/-0.010	<i>1.454</i>	<i>/</i>			
0.500	+/-0.010	<i>.502</i>	<i>/</i>			
3.352	+/-0.010	<i>3.356</i>	<i>/</i>			
0.800	+/-0.010	<i>.804</i>	<i>/</i>			
1.563	+/-0.010	<i>1.563</i>	<i>-</i>			
2.313	+/-0.010	<i>2.316</i>	<i>/</i>			
1.156	+/-0.010	<i>1.157</i>	<i>/</i>			
0.500	+/-0.010	<i>.504</i>	<i>/</i>			
0.624	+/-0.010	<i>.626</i>	<i>/</i>			

